



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6210G02631-8G

Job Sheet 198931



Part No: RBW6210G02631-8G

Job Qty: 1 pcs

Part Name: M/R Blade Trim Tab Bending Gauge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6210G02631-8G Rev.B IPP Rev. A 18.10.11 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/14/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	10/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S227832



Part: RBW6210G02631-8G

Job No: 198931

Serial No/Batch: S227832

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 10/29/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	M6L
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	10/14/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 110 - Small Fab - 1-Assemble as per DWG. See note 8,9,10,11 and 12. ***Trim to fit -9 as required see DWG sheet 10
 Descriptions: note 8.***

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ -The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - QC21- Final Inspection - Work Order Release

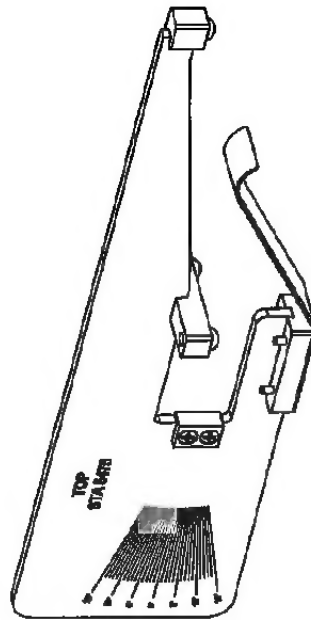
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90273A192	Steel Phillips Flat Head Screw #8-32 x 3/8" Long	2 Ea (2 ea)	110-Small Fab - 1	#110442
MS20470AD4-10	Rivet	4 Ea (4 ea)	110-Small Fab - 1	FAL128257
RBW6210G02631-8G-1	Plug	3 pcs (3 ea)	110-Small Fab - 1	5140917
RBW6210G02631-8G-2	Protection	1 pcs (1 ea)	110-Small Fab - 1	3213770
RBW6210G02631-8G-3	Gauge Assembly	1 pcs (1 ea)	110-Small Fab - 1	5222700
RBW6210G02631-8G-8	Spring Plate	1 pcs (1 ea)	110-Small Fab - 1	5132526
RBW6210G02631-8G-9	Spring Plate Protection	1 pcs (1 ea)	110-Small Fab - 1	5136363

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	90273A192	2	100	0
	MS20470AD4-10	4	437	0
	RBW6210G02631-8G-1	3	30	0
	RBW6210G02631-8G-2	1	0	0
	RBW6210G02631-8G-3	1	0	0
	RBW6210G02631-8G-8	1	6	0
	RBW6210G02631-8G-9	1	20	0
Part Specifications				
Specifications could not be found.				

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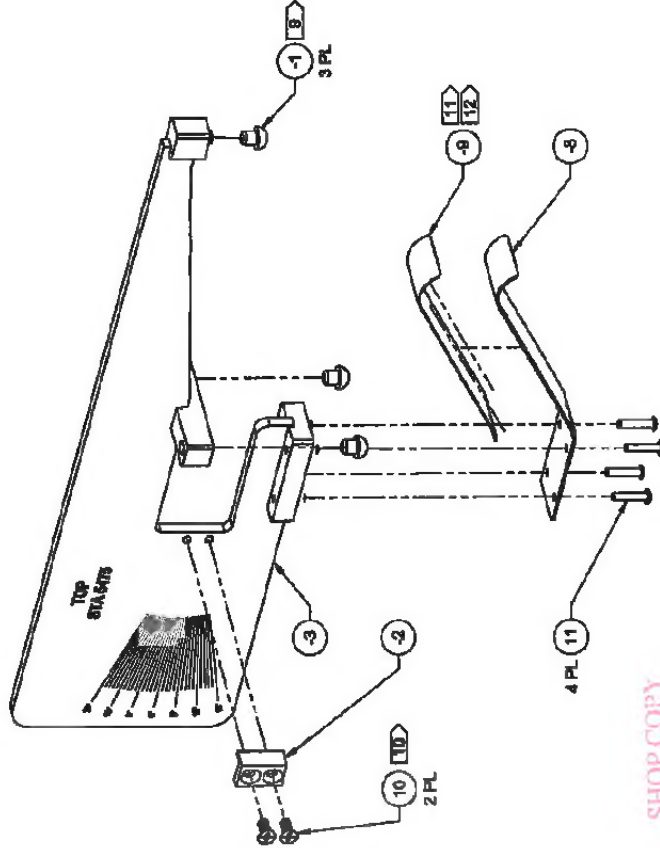
ITEM #	QTY	PART #	PART TITLE
-1	3	RBW8210G02831-8G-1	PLUG
-2	1	RBW8210G02831-8G-2	PROTECTION
-3	1	RBW8210G02831-8G-3	GAUGE ASSY
-4	1	RBW8210G02831-8G-4	SPRING PLATE
-5	1	RBW8210G02831-8G-5	SPRING PLATE PROTECTION
10	2	McMaster#0273A102 OR EQUIV.	STEEL PHILLIPS FLAT HEAD SCREW #0-32 X 3/8" LG.
11	4	MS20470AD4-10	ALUMINUM RIVET 1/8" DIA. X 6/8" LG.



RBW8210G02831-8G M/R BLADE TRIM TAB BENDING GAUGE

(13)

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) IDENTIFICATION: N/A
 - 8) APPLY LOCITITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -1 WITH ITEM -3 AND REMOVE EXCESS
 - 9) APPLY RED THREADLOCKER LOCITITE 263/262 ON THREADS OF ITEM 10 THEN ASSEMBLE WITH ITEM -3 AND REMOVE EXCESS
 - 10) APPLY RED THREADLOCKER LOCITITE 263/262 ON THREADS OF ITEM 10 THEN ASSEMBLE WITH ITEM -3 AND REMOVE EXCESS
 - 11) ASSEMBLE ITEM -5 ACHIEVING SIDE ONTO ITEM -3 AS SHOWN AND TRIM EXCESS IF NECESSARY
 - 12) APPLY LOCITITE 605 BETWEEN THE SURFACES OF ITEM -3 AND ITEM -4 IF NECESSARY AND REMOVE EXCESS
 - 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



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RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 198930 WLS

19-08-07

B	-2 MAT'L WAS 6061-T6/7076-T6 IS NYLON 6 -3 CHD LOCATION OF Ø0.2420-0.2412 HOLE -1 MAT'L WAS PTFE IS NYLON 6	18-813	KPT
A	NEW ISSUE		KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DATE	9/25/2018		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBW8210G02831-8G TITLE M/R BLADE TRIM TAB BENDING GAUGE SCALE NTS CONFIDENTIALITY 0.5018 BY DART AEROSPACE LTD ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE FOR THE BUREAU OF THE AIR FORCE (B-10) (CONFIDENTIALITY)			

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				Date: _____ Sequence #: _____		QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation						Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY									
						Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
						Other/Details: _____									
Completed By _____						Lead hand / Supervisor _____									
QC / QA Coordinator _____															